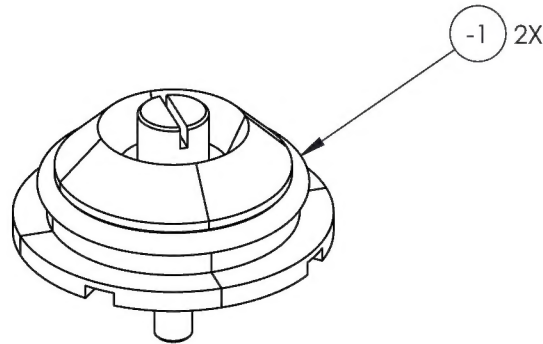
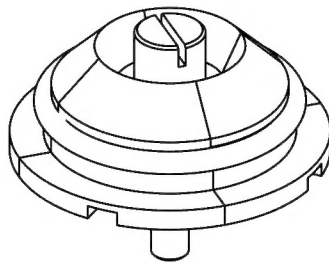


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	10/7/2016	RJC	JAG



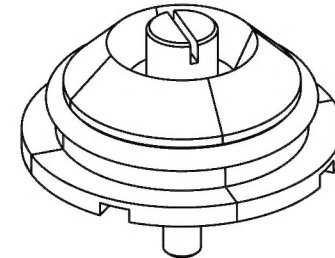
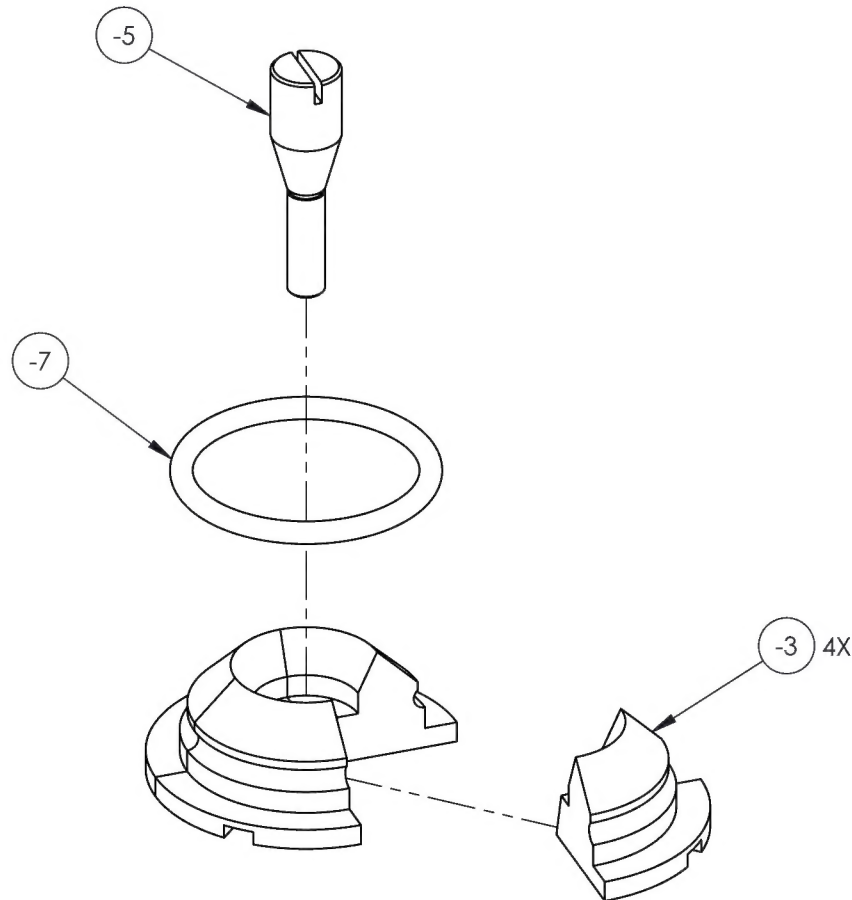
NOTE:
 1. REF. EUROCOPTER T/N: 105-13141W5.
 2. USED ON MODELS: EC135, EC145, H135, EC635, EC645.

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5	REV 1
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT Q&T	.XXX ± .005 FRACTIONS ± 1/8
FINISH AS PLATED	.XX ± .01 ANGLES ± 5°
SPEC AS PLATED	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	SEE NOTE
SCALE 1:1	DATE 7/22/2016
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING INSERT ASSEMBLY			2
	4		-3		STAKING INSERT	4140/4142		3
	1		-5		SCREW	4140/4142		4
		B/O	-7	1	O-RING	BUNA-N	Ø3mm X 30mm I.D. (MCMASTER-CARR #1174N608)	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

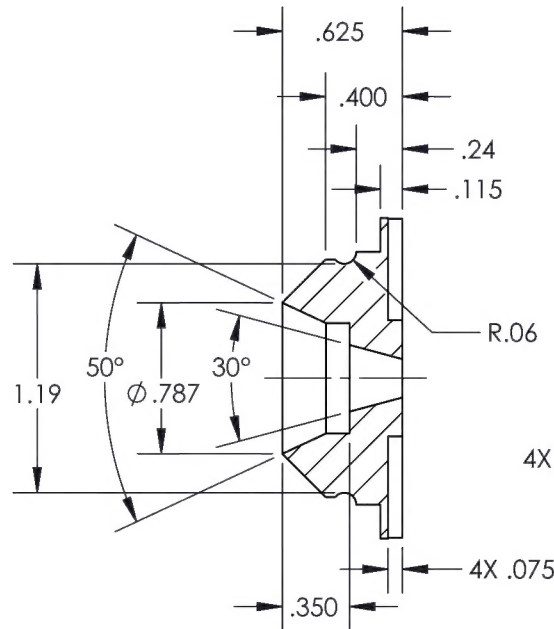
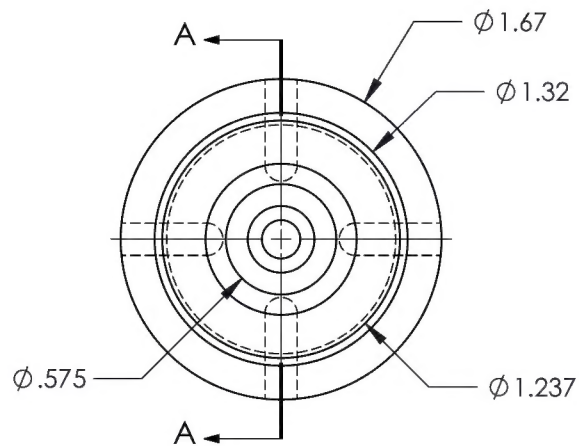


STAKING INSERT ASSEMBLY

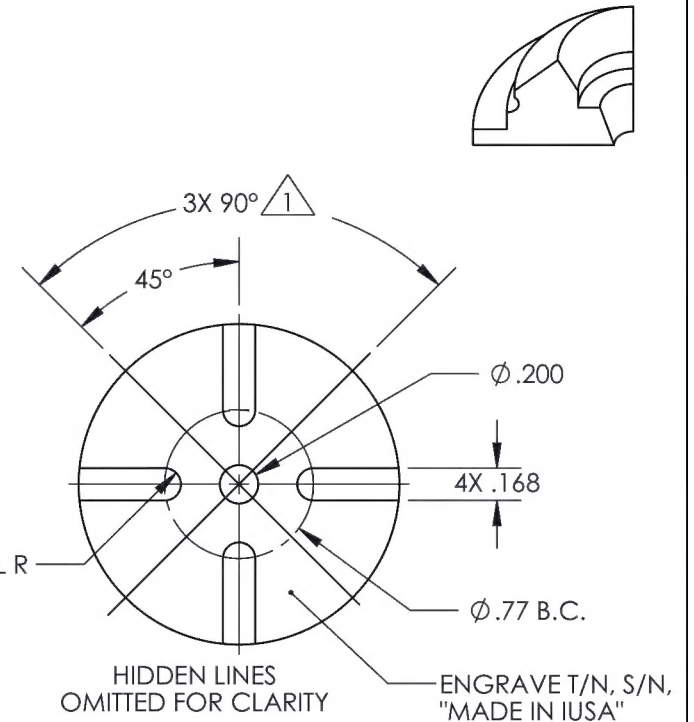
DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5-1	REV 1
MAT'L TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 7/22/2016
SHEET 2 OF 4	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A



NOTE:

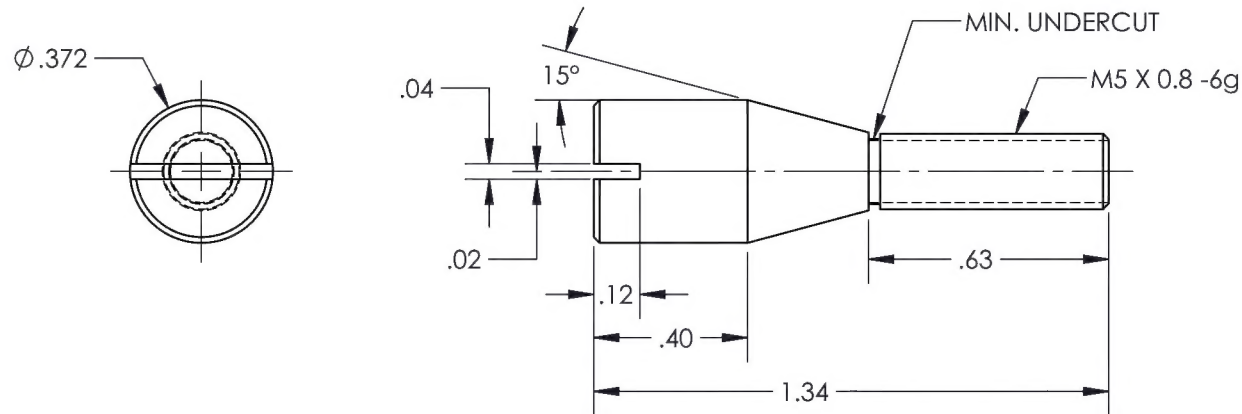
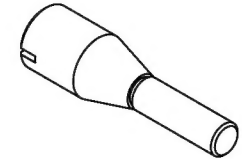
1 EDM TO SPLIT INTO 4 EQUAL PIECES.

(-3)
STAKING INSERT

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5-3	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125✓
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/22/2016	USED ON MODEL
SHEET 3 OF 4	EC145

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				APPROVED



(-5)

SCREW

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/21/2016	USED ON MODEL
SHEET 4 OF 4	EC145